

Date: Thursday, 3/30/2006 10:07:20 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STUD
Job Number : 26459	
Estimate Number : 11859	
P.O. Number : N/A	Part Number : D2374
This Issue : 3/30/2006 S.O. No. : N/A	Drawing Number : D2374 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 4/10/2006
Checked & Approved By : <u>06.03.30</u>	Qty: 45 Um: 40 Each
Comment : Est. D 03.04.04 Reformat; Made on Cobra KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELRI/R1000	Delrin Round Bar 1"
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Comment: Qty.: 0.1335 f(s)/Unit Total : 5.3382 f(s)

Delrin Round Bar 1"

Material: Black Acetal (Delrin) 1.00" Ø Rod (M-DELRIN-R1.000)

Batch: 1612806/04/05

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

Turn blank as per Folio FA156 and Dwg D2374

Deburr as required

06/04/05

45

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/04/05

45

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

06/04/05

45

5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA156 and Dwg D2374

06/04/06

45

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/04/12

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STUD

Job Number: 26459

Part Number: D2374

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MT 06/04/06

45

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr as required

MT 06/04/06

45

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MS 06/04/06

45

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Sty2*

Pe 06/04/06

45

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/04/06 *(45)*

Job Completion



u 06.06.07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

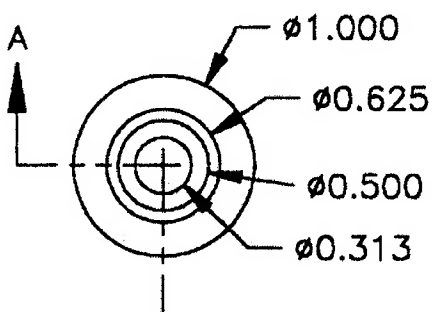
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

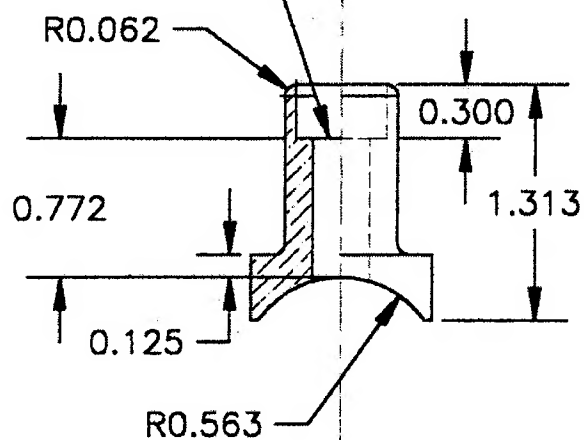
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	K HAND	DRAWING NO.	REV. A
CHECKED <i>BW</i>	APPROVED <i>[Signature]</i>	D2374	SHEET 1 OF 1
DATE	TITLE	SCALE	
95:02:24	STUD	1:1	



COUNTER BORE
 $\phi 0.500$ X 0.300 DEEP
 $\phi 0.313$ THROUGH



SECTION A

MATERIAL: DELRIN BLACK

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26459